

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005661**Date Inspected:** 11-Feb-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Shen Fu You			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG		

Summary of Items Observed:

On this day Caltrans OSM Quality Assurance (QA) Inspector Erik Prue was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA Inspector observed and/or found the following:

Bay 13 lifts 7BW and 7CW: QA Inspector randomly observed ZPMC qualified welder ID#2500066028 welding cover passes on seg 035A-018 (7CW) SP480A to SP520A Complete Joint Penetration (CJP) weld. Welder was observed welding in the 1G (flat) position utilizing the Submerged Arc Welding (SAW) process. QA Inspector observed the ZPMC QC Inspector Wu Bin verifying welding parameters and pre-heat were in accordance with the Welding Procedure Specification (WPS). QA Inspector with QC Inspector observed parameters as follows: preheat temperature to be at 78°C and measured the welding parameters to be 583 amps, 30.6 volts, a travel speed of 408 mm/min. Welding parameters verified by QA Inspector appear to be in general compliance with the approved WPS-B-T-2221-B-L2c-S2.

Bay 14 lift 6CW: QA Inspector observed Bottom Plates and Side Plates being placed in in west jig for fit up. QC Inspector informed QA Inspector that plates will be tack welded in place at a later date.

Bay 2: QA Inspector observed six (6) ZPMC workers performing cutting and grinding operations of weld repaired buttered edges of side plates on lifts 1AE and 1AW. Buttering was performed to repair incorrect dimensions on side plates. Representative pictures shown below.

Unless otherwise noted, all work observed on this date appears to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

No significant conversations this day.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prue,Erik	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
